

Date: Tuesday, 22/04/2008 3:53:32 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE		
Job Number	: 38759					
Estimate Number	: 12737					
P.O. Number	:			Part Number	: D353513	
This Issue	: 22/04/2008		S.O. No. :	Drawing Number	: D3535 REV B	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: B	
Previous Run	: 37584			Material	:	
Written By	:			Due Date	: 02/05/2008	
Checked & Approved By	: JLO 08.4.23			Qty:	16	Um: Each
Comment	: Est Rev:A New Issue 07-02-15 JLM			Est Rev:B As per Rev B 07-08-31 JLM	Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S20GA	304/316 .040 Sheet	
		Comment: Qty.: 0.8930 sf(s)/Unit Total : 14.2884 sf(s) 304/316 .040 Sheet (M304S20GA)	
		Batch: 107744 1B 8-4-25	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B	(1b)
		2-Deburr if necessary	1B 8-4-25
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	1B 8-4-25
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	1B 08/04/20 1G
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158Identify as D3535-13	SB 08/05/13 1G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/04/2008 3:53:32 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 38759

Part Number: D353513

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S08/05/14 C16

coat
30m:1
15/05/2008

7.0 POWDER COATING

POWDER COATING



M105642



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-f

08/0

#1 323.0 F
#2 338.751 F
#3 0353513 F
#4

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



g1



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-15

(X16)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-16

g1

08-05-15

(X16)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/16 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



m-f 08-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

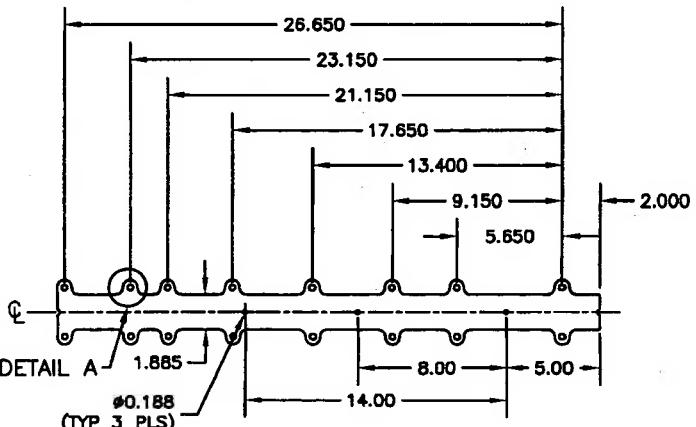
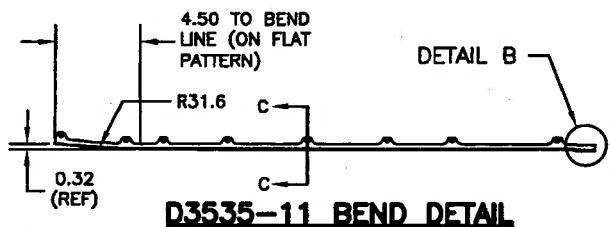
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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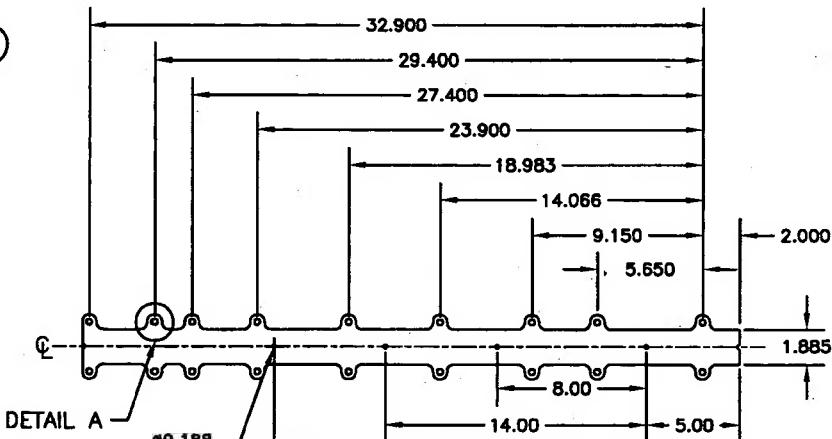
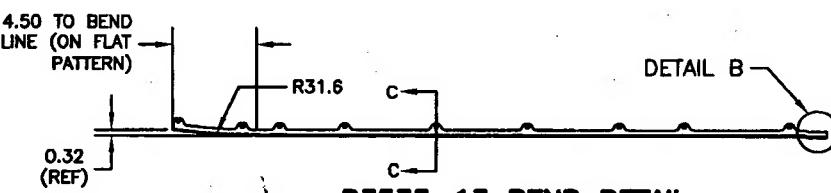
07.04.24

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

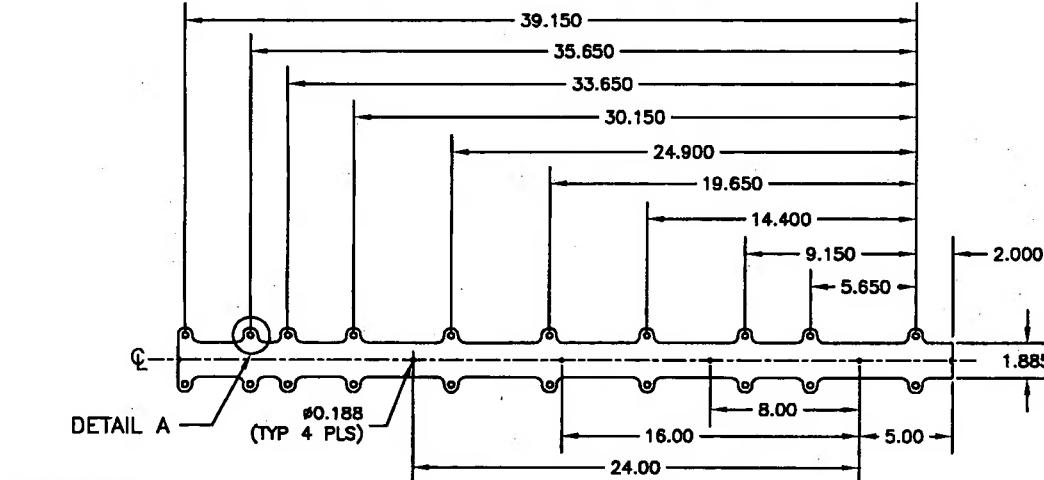
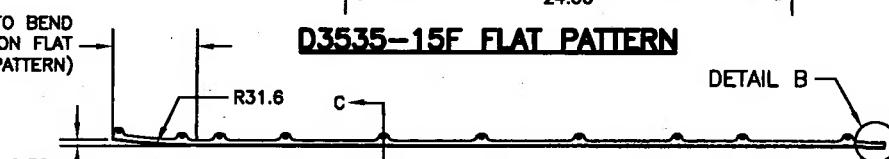
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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

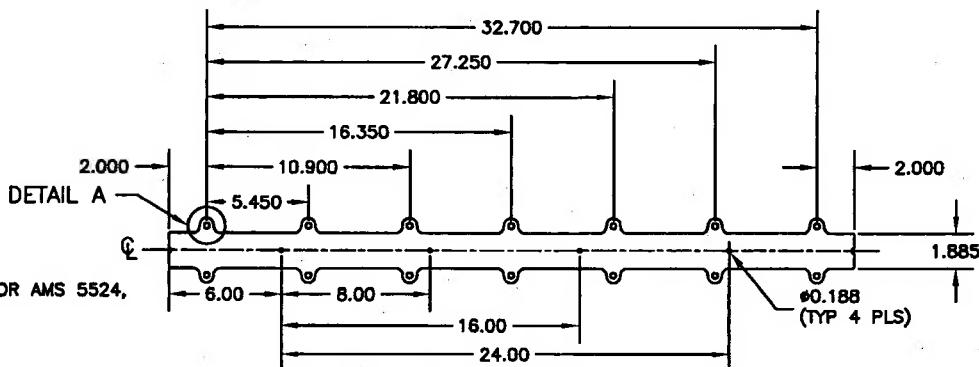
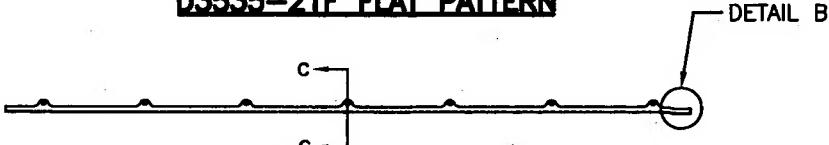
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CHECKED	APPROVED	DRAWING NO.
DATE		SHEET 1 OF 7
CB	PH	D3535
07.04.17		MOVE TAB OUTBOARD, ADD AMS SPEC
A	06.10.25	WEARSHOE
B	07.04.17	NEW ISSUE

DARTRELEASED
07.04.24**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL**

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

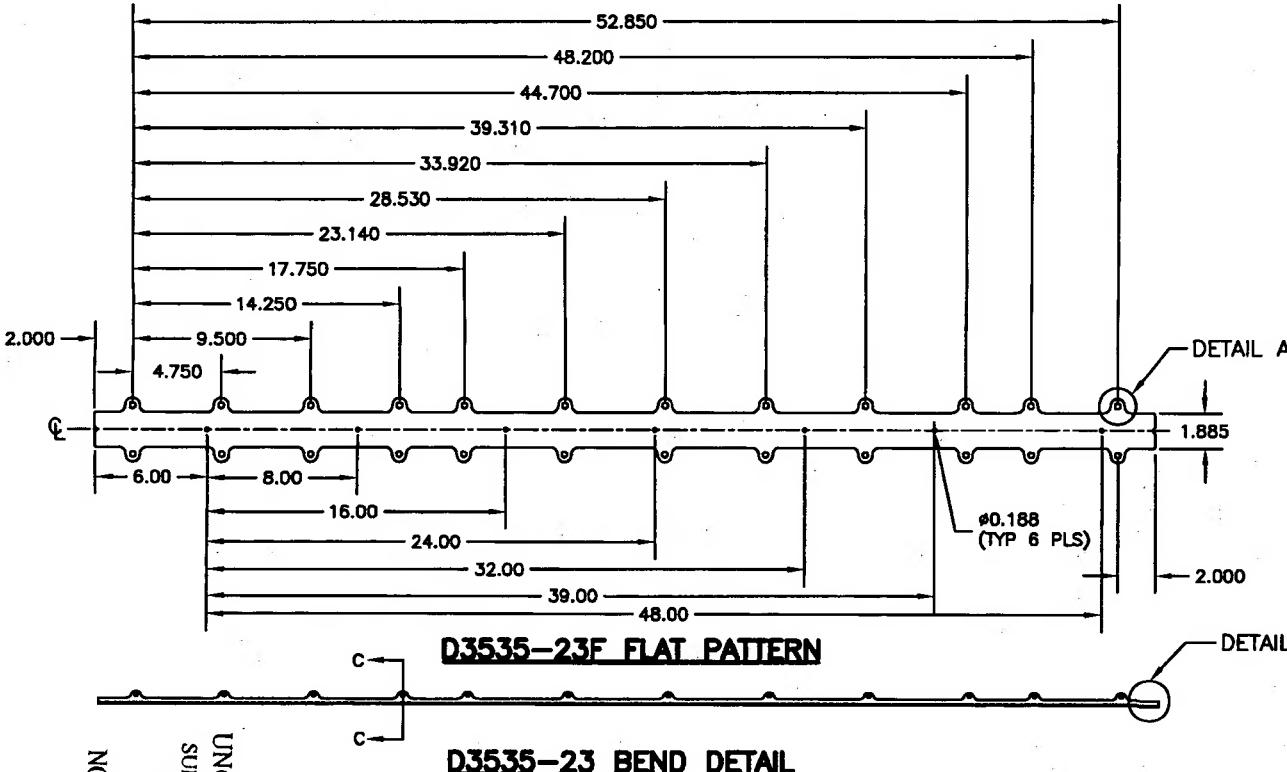
**D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

DESIGN <u>CB</u>	DRAWN BY <u>PH</u>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
CHECKED <u>HF</u>	APPROVED <u>HF</u>	DRAWING NO. D3535	SHEET 2 OF 7
DATE 07.04.17	TITLE WEARSHOE	SCALE 1:10	

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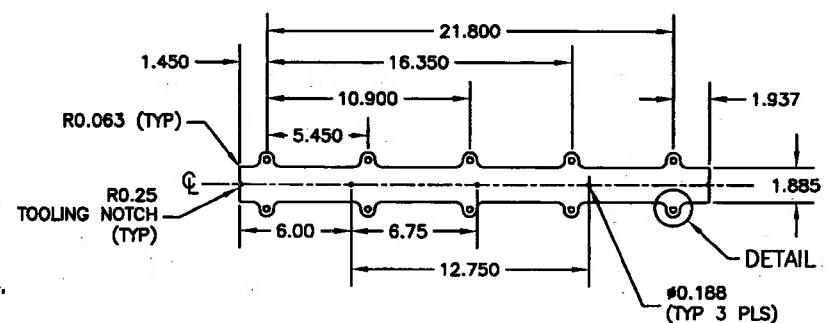
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NOTES

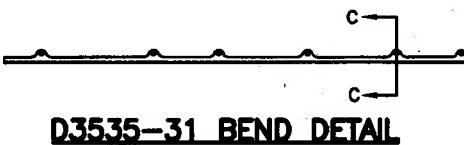
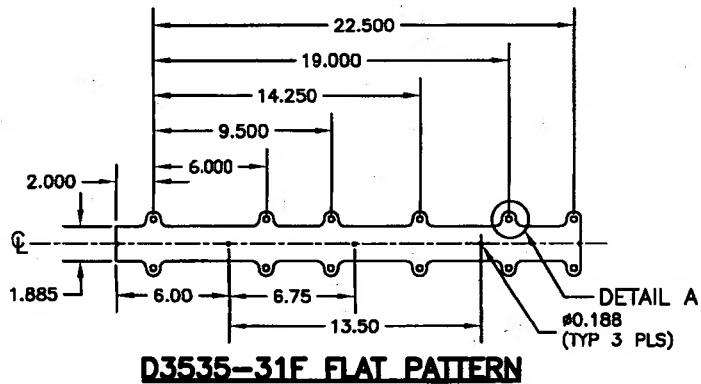
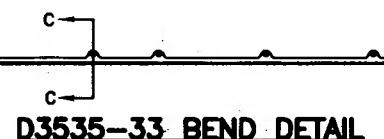
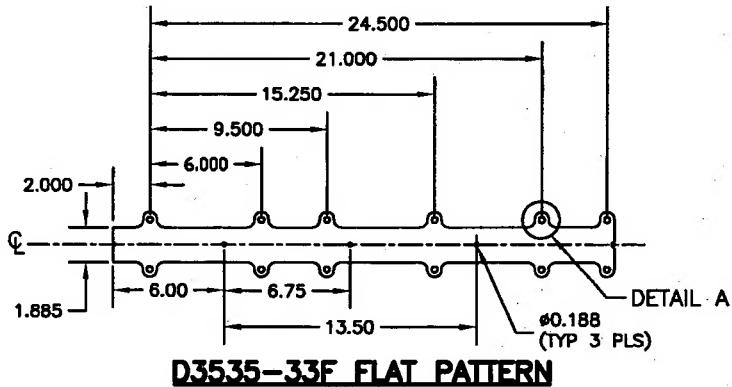
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20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
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/	/	D3535
DATE		TITLE
07.04.17		WEARSHOE
REV. B	SHEET 3 OF 7	SCALE
		1:10

DART

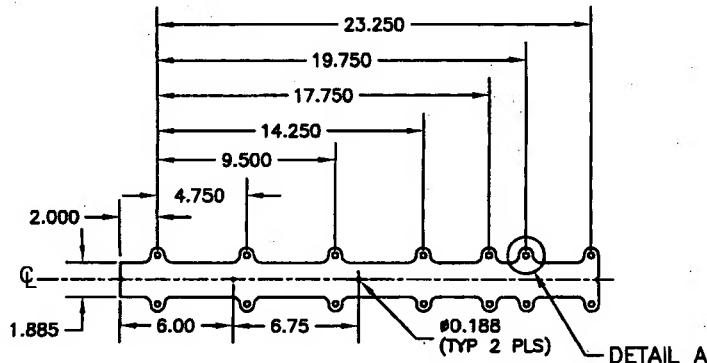
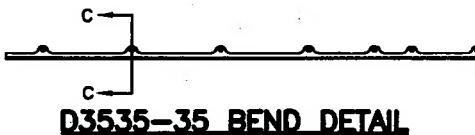
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CHECKED PH	APPROVED PH	DRAWING NO. D3535
DATE 07.04.17	TIME WEARSHOE	REV. B SHEET 4 OF 7 SCALE 1:10

RELEASED
07.04.17

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304520GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
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07.04.17**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL**

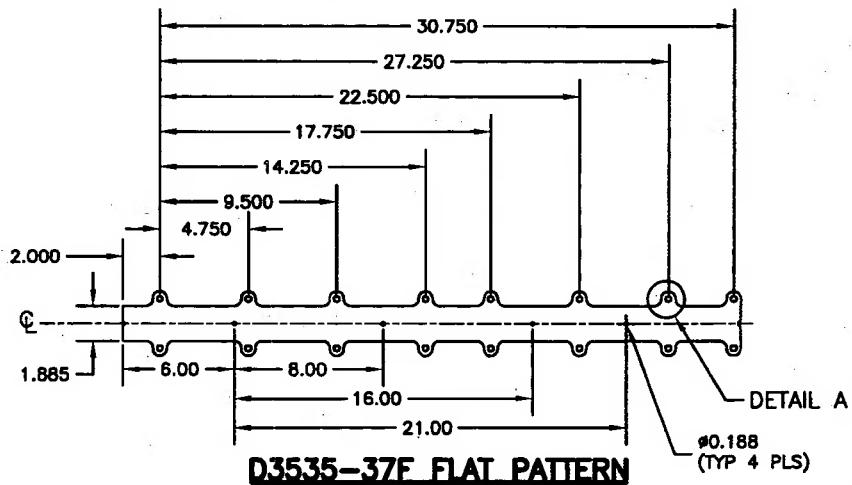
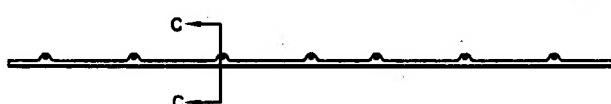
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NOTES

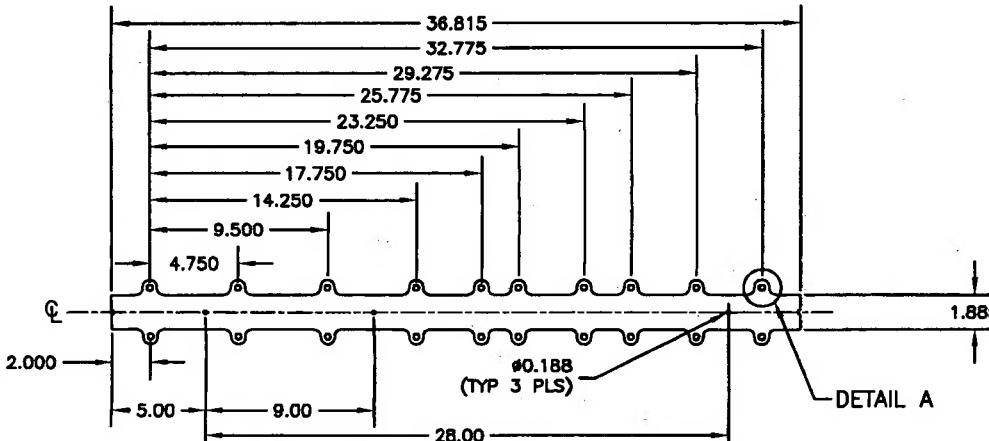
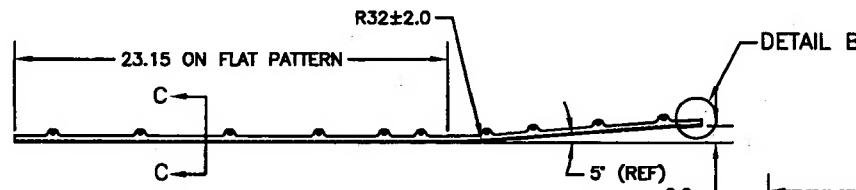
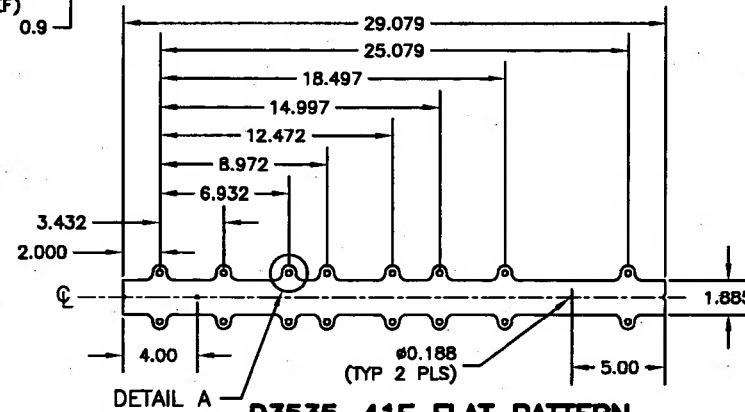
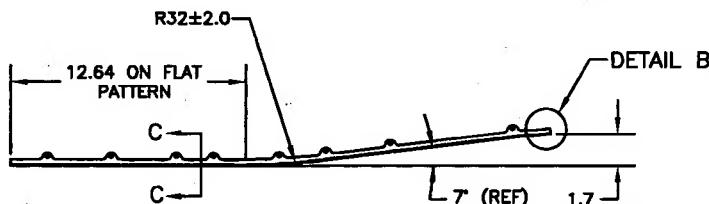
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(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
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**D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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C.B	P.H	DRAWING NO. D3535	SHEET 5 OF 7
CHECKED	APPROVED	DATE 07.04.17	SCALE 1:10

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07.04.24**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

DESIGN C.B	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
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DATE 07.04.17	TITLE WEARSHOE	SHEET 6 OF 7
		SCALE 1:10

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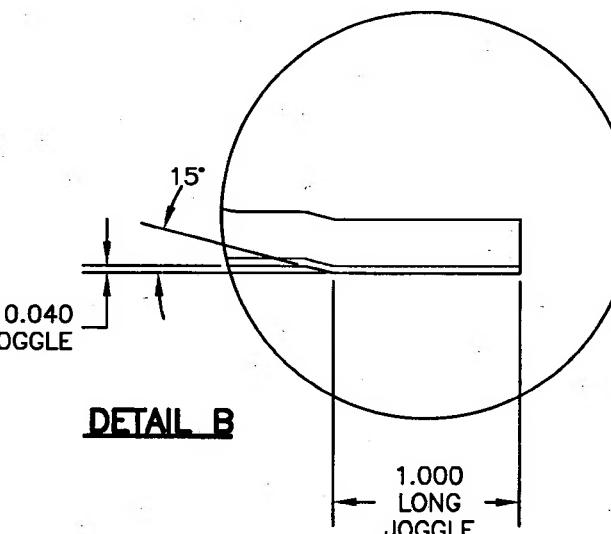
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(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
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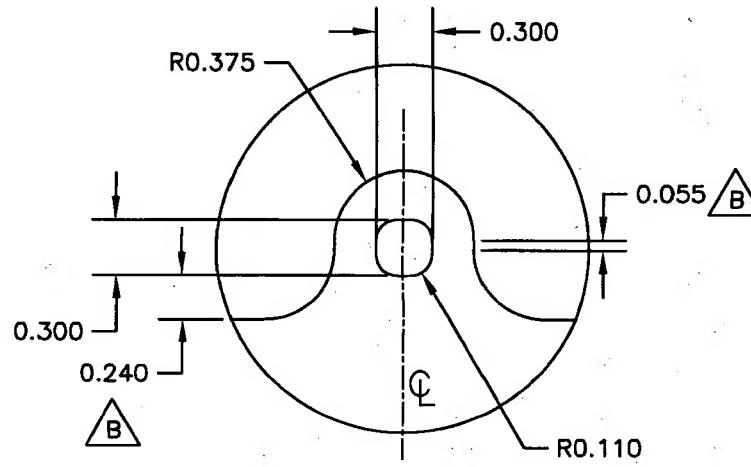
DART

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C8	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE		TITLE
07.04.17		WEARSHOE
		SHEET 7 OF 7
		SCALE
		1:1

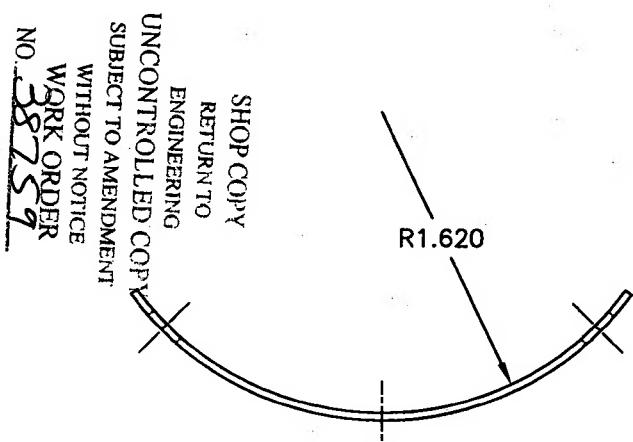
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DETAIL B



DETAIL A



SECTION C-C

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DART AEROSPACE LTD	Work Order:	38759
Description: WEAR SHOE	Part Number:	D3535-13
Inspection Dwg: D3535-13 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:	J	Prototype Approval:	1
Date:	8-4-25	Date:	08/04/25	Date:	2

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

